Work Order Thursday, Septe											Page 1
Item ID: Revision ID: Item Name:	D3622-1 Ball Stud			Accept					•		
Start Date: Required Date: Reference:	9/30/2010 10/8/2010	Start Qty: 20.00 Req'd Qty: 20.00	1 1 1 1 1 1 1 1 1 1		Cust Item ? Customer:	ID:					
Approvals:	Process Pla	nn:	Date: <u>/0-9-30</u> Date:	Tooling: SPC (Y/N):		ate:					
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numbe	Insp. r Stamp
Draw Nbr D3622	Rev	vision Nbr									
100 Hardinge Hardinge CNC Lath		Hardinge CNC LATHE : Memo 1-TURN AS FOLIO REV DWG REV:	S PER FOLIO FA686 & DWG	0.00 0.00 G D3622,	,			J0)	<u></u>	<i>'</i>	
110 QC Quality Control		2-DEBURR QC2- Inspect parts off m Memo		0.00 0.00 () () () ()				la	_ Ø	<i>,</i>	.
120		QC8- Inspect parts - seco	ond check	0.00						/	

QC

Memo

Quality Control

B.A 10/10/06

W/O:			WC	ORK ORDER CHANGE	S				x 4
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	Date:	
	R	esolution:	Dispositio	n:	QA: N/C C	losed:		Date: _	
NCR:		\	WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
		Description of NC	NC Corrective Action S			Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Chief Eng	QC Inspector
						,			

Work Order ID 62474

Thursday, September 30, 2010 2:20:01 PM



Page 2

Item ID:

D3622-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Ball Stud

9/30/2010

Start Qty: 20.00

Operation

Description

Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Tool ID

Run

Start

Stop



Required Date: 10/8/2010

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Sequence ID/ Work Center ID

130

Packaging Packaging

Memo

Memo

0.00

0.00

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

W/O:		<u> </u>	WO	RK ORDER CHANG	GES				t. 3
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									-
		.,,							
Part No		PAR #:	Fault Categ	ory:	NCR: Yes	s No DQ	A :	_ Date: _	
	Res	olution:	Disposition	:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			ction B		cation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat		ion C	Chief Eng	QC Inspector
							,		
					1				

Picklist Print

Thursday, September 30, 2010 2:20:05 PM

Work Order ID: 62474

Parent Item:

D3622-1

Parent Item Name: Ball Stud



Start Date: 9/30/2010

Required Date: 10/8/2010

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A New Issue 07-04-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500		Purchased	No			100	f	124.8880	0.108	2.27368			

303 HEX BAR .500

Location Loc Oty Loc Code MAT037 124.888 **109778** 100.888 109846 24

	T									
W/O:			W	ORK ORDER CHANGI	ES					т в
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	D	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					l 					
									·	
						_				
Part No		PAR #:	Fault Cate	egory:	 _ NCR: Ye	es No	DQA:		Date:	
		esolution:								
NCR:			WORK ORD	ER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC		Corrective Action Section			Verifica	tion	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		n & ite	Section	C C	Chief Eng	QC Inspector
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				740-						
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DART AEROSPACE LTD	Work Order:	42474
Description: Ball Stud	Part Number:	D3622-1
Inspection Dwg: D3622 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

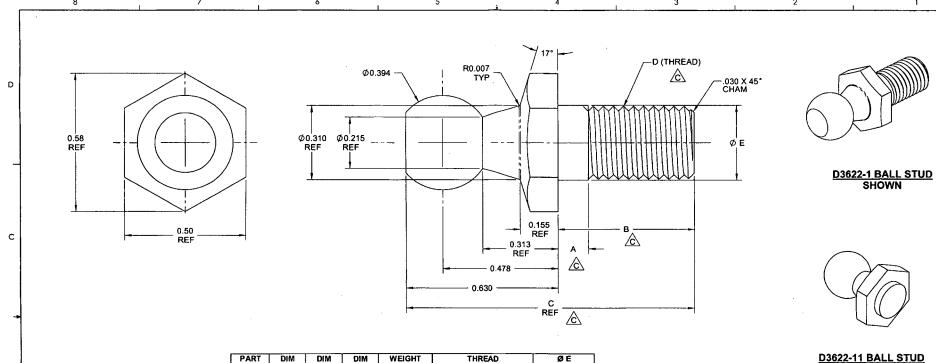
	X	First Artic	le	_ Proto	type
Drawing	Tolerance	Actual	Accent	Reject	Meth
Di	Tolerance	Dimension	Accept	Keject	Insp

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.19	+/-0.030	1,192			Velh	PLZ
0.630	+/-0.010	.633			- <	•
0.563	+/-0.010	.564)	~ ~
0.125	+/-0.010					
0.155	+/-0.010	157				
Ø0.310	+/-0.010	0,378	/			
Ø0.215	+/-0.010	0.215	/			
Ø0.394	+/-0.010	0.394	/		Mic	8N-5
R0.007	+/-0.010	ROOF	/		Icel Red	
0.3125-24UNF-3A	+0.000/-0.001	3123-24006-34			THREAD GAGE	ref.
Over wires	Min = 0.3336 Max = 0.3363	3345			Mic.	51-5
						

	\ \						
Measured by:	2		Audited by:	H. A. L.	Prototype Appro	val:	N/A
Date:	10/	1005	Date:	/ / / /	D	ate:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.04.15	New Issue	KJ/DD /A	
В	10.02.02	Dwg Rev updated	KJ 🛠	
			4//	• •

W/O:			WO	RK ORDER CHANG	SES					
DATE	STEP	PR	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	_ NCR:	Yes N	10 DQ	A :	Date: _	
	Re	solution:	Disposition		QA: I	VC Clo	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR))			
DATE	STEP	Description of NC			tion B	Cian 9	Verific		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
							,			E
,										



PART	DIM	DIM	DIM	WEIGHT	THREAD	ØE
NUMBER	A_	В	С	(LBS)	D	MiNMAX_
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053 0.3125
D3622-3	0.125	-0.563-	-1:19	0.03	0.1875-32UNF-3A	0.1840 0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053 0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053 0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053 0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270 0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053 0.3125

D3622-X BALL STUD

SHOP COLL

Richard

ENGINES, de 14

UNCONTROLLER CONTR

SUBJECT TO AMEND MEDICAL

WITHOUT NO GLE

С	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20	
В	ADD -3 (SHEET 2)	HS	09.09.18	
Α	NEW ISSUE	MB	07.04.13	
REV.	DESCRIPTION	BY	DATE	

1120		DEGOIGH HOLY	01	_ D/_		
DESIGN	JPH	DART AEROSPACE LTD				
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA				
CHECKED	A- (DRAWING NO.		REV. C		
MFG. APPR.	[/2]	D3622		SHEET 1 OF 1		
APPROVED	7800	TITLE		SCALE		
DE APPR.	-14	BALL STUD		NTS		
DATE 10.0	7.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT OF PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS				

REF DART SPEC M303H0.500

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044

7) WEIGHT: SEE D3622-X TABLE 8

NOTES:
1) MATERIAL: AISI 303 HEX BAR
....REF DART SPEC M303H0.500

7

SHOWN

W/O:		WORK ORDER CHANGES							٠, .
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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						,			!
						-			
				•					
		PAR #:	Fault Cate	jory:	_ NCR: Ye	s No I	DQA:	Date: _	
		solution:	Disposition	ı:	QA: N/C Closed:			Date:	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section B		Ve	rification	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	ې ۱&	Section C	Chief Eng	QC Inspector
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